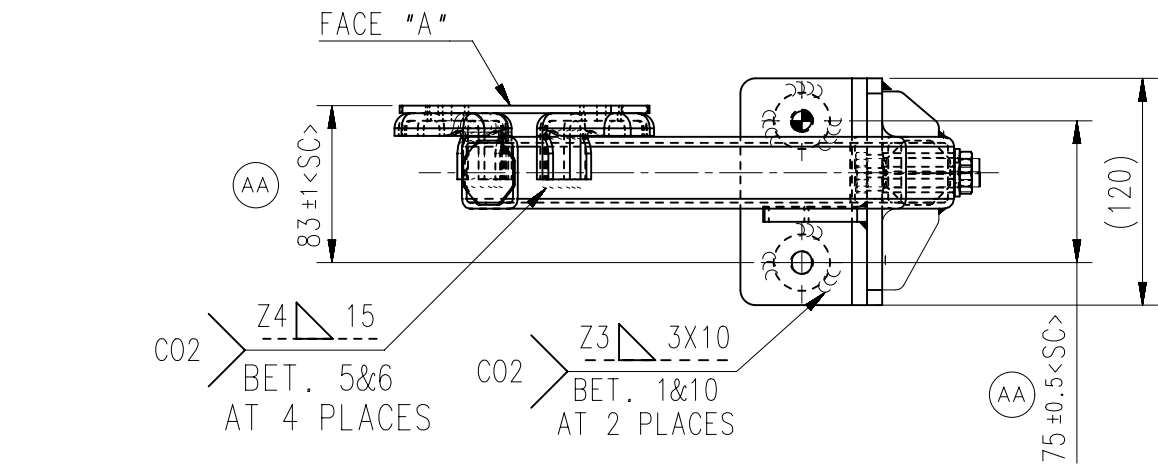
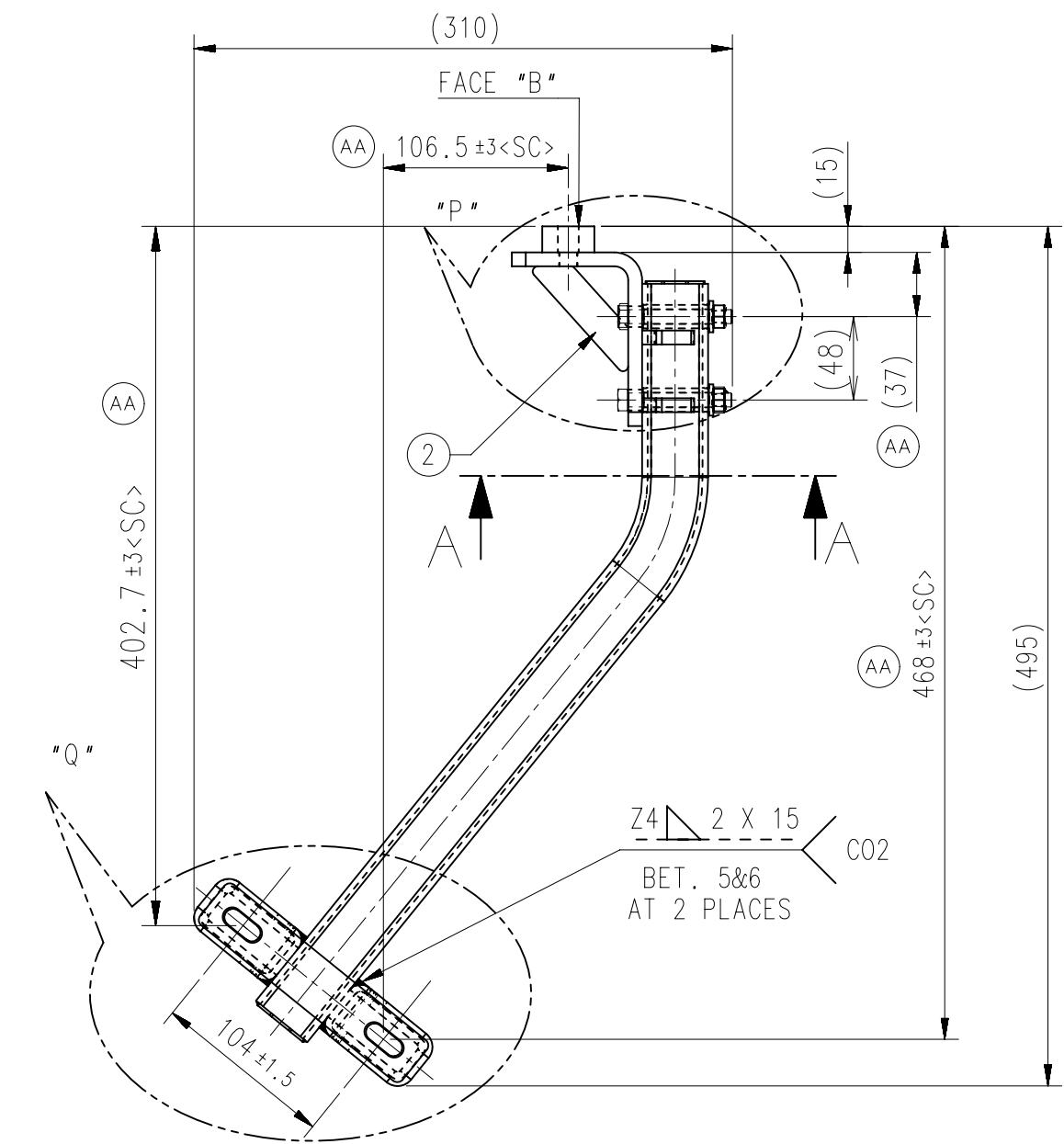




WELDING DETAILS:- (AA)

WELDING BETWEEN	WELDING LENGTH(CO2)			
	Z2	Z3	Z4	Z8
1&2	--	--	--	60
1&3	--	--	--	80
1&4	--	--	--	160
1&5	--	--	60	--
1&10	--	--	60	--
3&5	--	--	90	--
4&5	--	--	90	--
5&6	--	--	120	--
5&8	80	--	--	--
5&9	--	40	--	--
6&7	--	150	--	--
11&12	--	20	--	--

NOTE:-

- DO NOT PRIME HOLE ID.
- UNPRIMED SURFACES TO BE COATED WITH RUST PREVENTIVE OIL.
- FACE 'A' & FACE 'B' SHOULD BE FREE FROM WELD SPATTER.

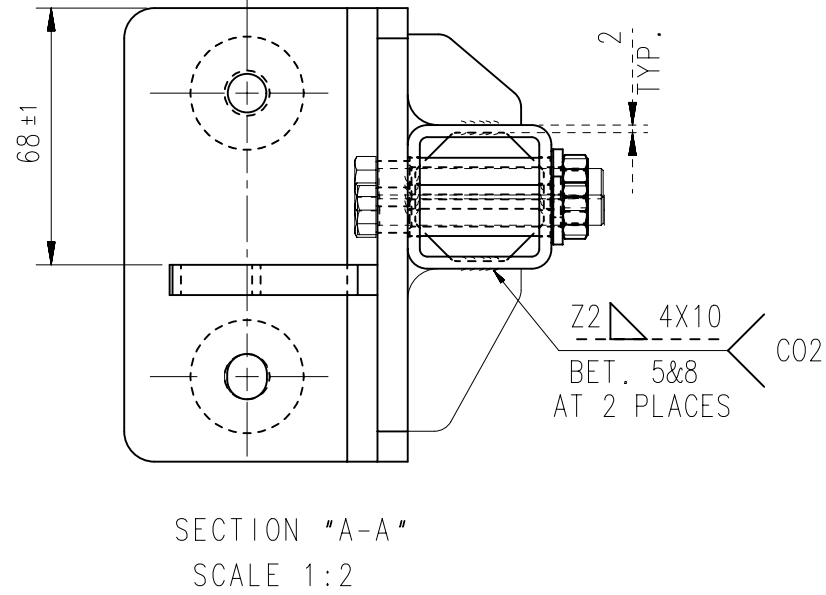
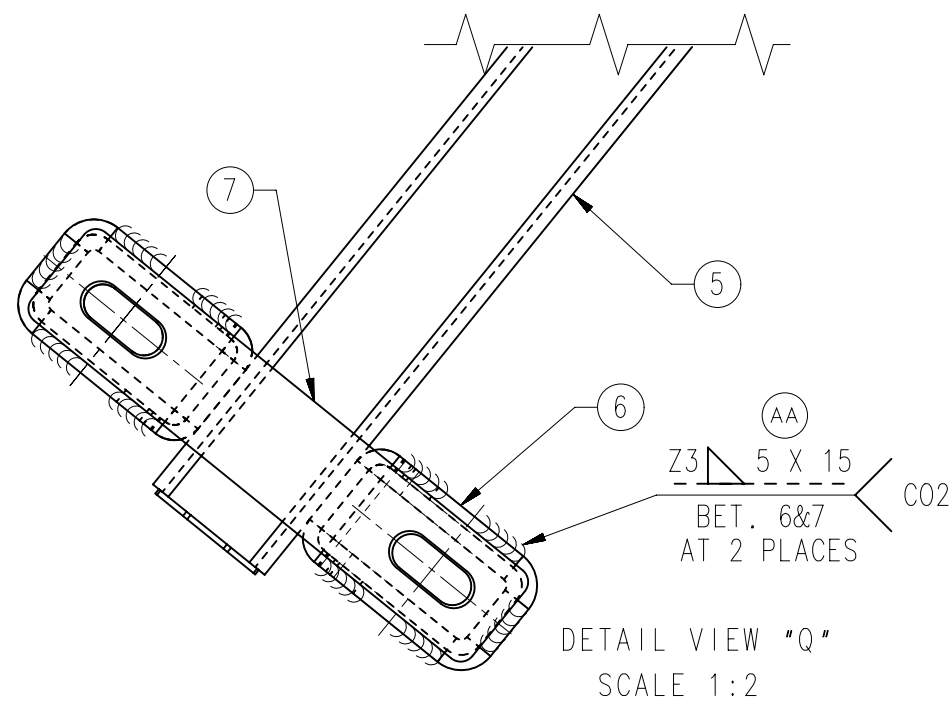
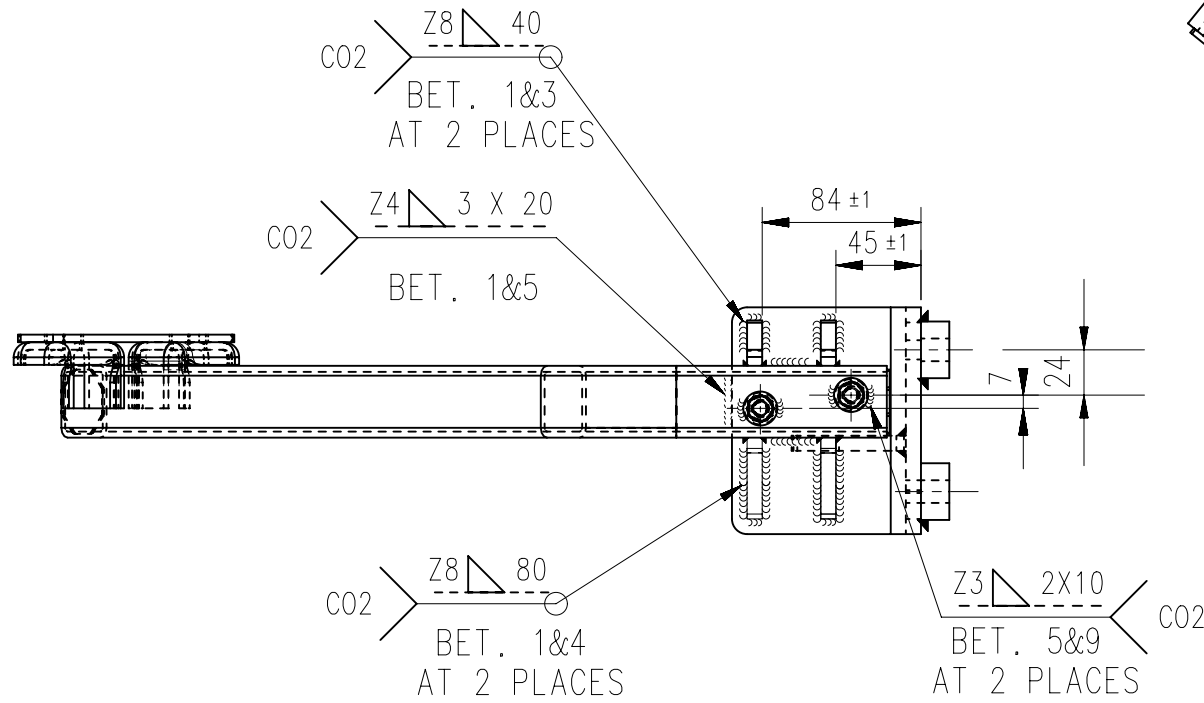
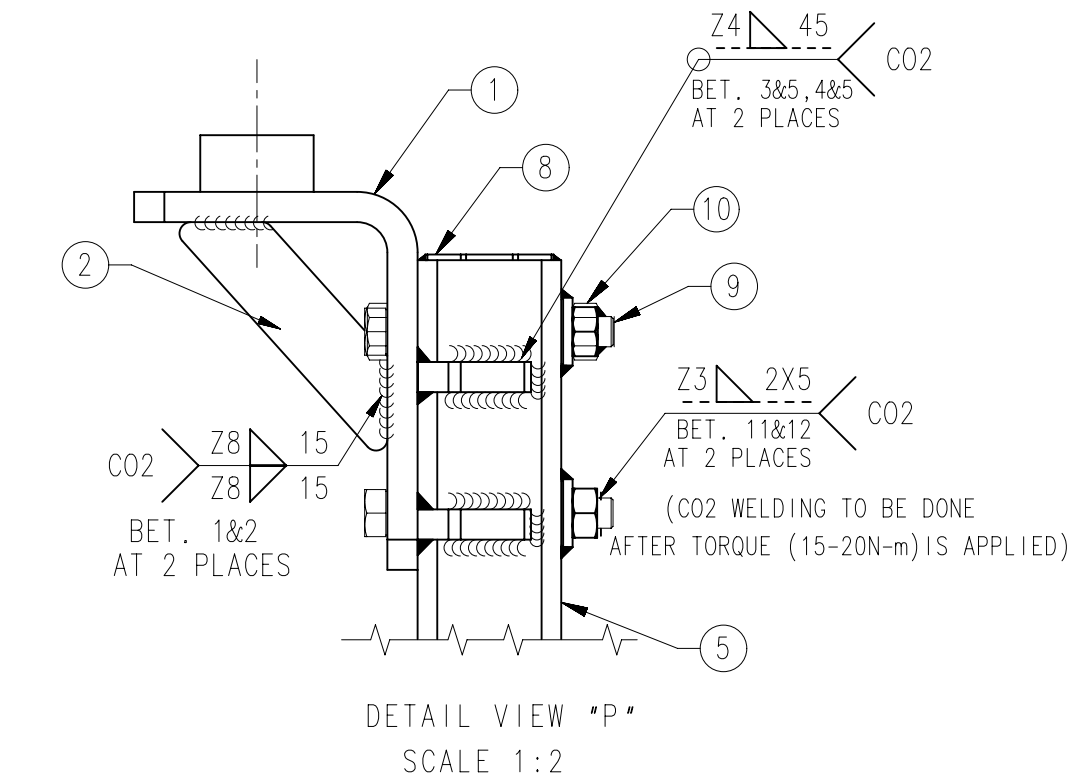
TOTAL SURFACE AREA : 204588mm²

PROCUREMENT CONDITION:-

PART NO.	SUPPLY CONDITION
0P7543919C91	PRIMED AS PER T04 308-0230

TOTAL WELD LENGTH AS PER PS:608:- (AA)

Z2	-	80mm
Z3	-	210mm
Z4	-	420mm
Z8	-	300mm



UNSPECIFIED TOLERANCE:
FOR ASSEMBLY
GENERAL TOLERANCE:
UP TO 300 : ±0.8
ABOVE 300 : ±1.0
ANGULAR TOLERANCE : ±1°

12.	STD	M8 WELDNUT	CLASS 8 AS PER IS:1367	2	0.001
11.	STD	M8 X 1.25 X 60 HEX BOLT	CLASS 8.8 AS PER IS:1364	2	0.051
10.	007543876C1	SPACER FOOT STEP	FE410W A, IS-2062	2	0.140
9.	007543871C1	BUSH	FE410W A, IS-2062	2	0.057
8.	007543881C1	END PLATE	MM21*D*1.5mm THK. AS PER GO 00167	2	0.022
7.	007543926C1	FOOT PLATE MTG L BKT CONTG PLATE	MM 11 D-4mm, THK AS PER G00 0169	1	0.124
6.	007543925C1	FOOT PLATE MTG L BKT	MM 11 D-4mm, THK AS PER G00 0169	2	0.234
5.	007543924C1	FOOT STEP MTG TUBE	38X38X3.2mm TUBE AS PER IS:4923 GRADE Yst310	1	1.663
4.	007543923C1	FOOT STEP MTG BKT GUSSET BOTTOM	MM 13 410-8mm, THK AS PER G00 0169	2	0.114
3.	007543922C1	FOOT STEP MTG BKT GUSSET TOP	MM 13 410-8mm, THK AS PER G00 0169	2	0.072
2.	007543921C1	FOOT STEP MTG BKT GUSSET FRONT	MM 13 410-8mm, THK AS PER G00 0169	1	0.083
1.	007543920C1	FOOT STEP MTG BKT (HOUSING)	MM 13 410-8mm, THK AS PER G00 0169	1	1.192
S.N.	PART NO.	PART NAME	MATERIAL	QTY	WT(Kg)

BILL OF MATERIAL:-

<SC> :SIGNIFICANT CHARACTERISTICS ▽:CRITICAL CHARACTERISTICS																																																																					
BREAK SHARP CORNERS MAY BE EITHER A CHAMFER OR A RADIUS FROM 0.2 mm MIN. TO 1.0 mm MAX.							MAHINDRA & MAHINDRA LIMITED TRACTOR DIVISION KANDIVLI(EAST), MUMBAI 400 101, INDIA.																																																														
UNSPECIFIED TOLERANCES AS PER ISO-2768-1:1989							E.R. / PROC.REQ.NO : ER14C0002710							PART NO. : 007543919C91																																																							
DIMENSIONS							PART NAME : FOOT STEP MOUNTING ASSY LH							MATERIAL : REFER B.O.M							HEAT TREATMENT : -----																																																
LINEAR IN mm.		OVER UPTO	0.5 3	1 6	3 30	6 120	30 400	120 1000	400 2000	1000 4000																																																											
f FINE (X.XXX)		(X.XXX)		±0.05		±0.05		±0.1		±0.15		±0.2		±0.3		±0.5		-																																																			
m MEDIUM (X.XX)		(X.XX)		±0.1		±0.1		±0.2		±0.3		±0.5		±0.8		±1.2		±2																																																			
c COARSE (X.X)		(X.X)		±0.2		±0.3		±0.5		±0.8		±1.2		±2		±3		±4																																																			
v VERY COARSE (X)		(X)		±0.5		±1		±1.5		±2.5		±4		±6		±8																																																					
ANGULAR IN deg.		OVER UPTO		-		10		50		120		400		400																																																							
f FINE (X.XXX)		(X.XXX)		±1°		±0°30'		±0°20'		±0°10'		±0°5'																																																									
m MEDIUM (X.XX)		(X.XX)		±1°30'		±1°		±0°30'		±0°15'		±0°10'																																																									
c COARSE (X.X)		(X.X)		±3°		±2°		±1°		±0°30'		±0°20'																																																									
v VERY COARSE (X)		(X)		±3°		±2°		±1°		±0°30'		±0°20'																																																									
PART OF THIS DRAWING / DOCUMENT SHOULD NOT BE REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION OF M & M LTD.														DESIGNER OVK																																																							
COMPUTER GENERATED DRAWING DO NOT CHANGE MANUALLY														CHECKER OVK																																																							
IF IN DOUBT, ASK														DO NOT SCALE														DRG SIZE : A2														ALL DIMENSIONS ARE IN mm.														CHECK DRG WITH LATEST CHANGE No													

ER2110000044	AC	PART RE- INSTATED	HKM	TVK	VB	24/05/21
ER14C0002710	AB	PRODUCTION RELEASE	AVA	OVK	RNM	04/07/14
ECNP0136942	AA	DIM. (48±0.8, 37±0.8 AND 15) MADE REFERENCE, DIM. ADDED (402.7±3) ,WELDING Z3 WAS Z4 between 6&7, WELDING TABLE AND WELD LENGTH UPDATED, SN 1&5 UPDATED AS PER SUPPLIER FEEDBACK	AVA	OVK	RNM	13/3/13
E.R.NO.	LET	LOC	REVISIONS	DSNR	CKR.	APPR. DATE